

Product Data Sheet

Stainless steel Rutile electrode

SUPER OPTIMAL 318

Classification

AWS A5.4 : E 318 - 16

DIN EN ISO 3581-A : E 19 12 3 Nb R 12

DIN EN 1600 : E 19 12 3 Nb R 12

Werkstoff Nr: 1.4576

Description and applications

Rutile-basic coated MMA Electrode for Welding Stabilized austenitic, stainless Cr-Ni-Mo steels and cast steels at working temperatures upto +400°C. Good fusion of joint faces, without spatters, finely rippled bead surface, very easy slag removal, easy striking and restriking. Packed in vacuum packed system.

Base materials

Material No.	Steel	Material No.	Steel
1.4401	X4 CrNiMo 17 12 2	1.4571	X6 CrNiMoTi 17 12 2
1.4404	X2 CrNiMo 17 13 2	1.4573	X10 CrNiMoTi 18 12
1.4406	X2 CrNiMoN 17 12 2	1.4580	X6 CrNiMoNb 17 12 2
1.4408	G-X5 CrNiMo 19 10	1.4581	GX5 CrNiMoNb 19 10
1.4429	X2 CrNiMoN 17 13 3	1.4583	X10 CrNiMo NSI 812

Typical Weld Metal Chemical Composition (%)

C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Ferrite
0.03	0.80	0.90	0.010	0.020	18.50	12.00	2.60	0.40	Austenite with Approx. 8% Ferrite

All weld metal Mechanical Properties (Typical)

Yield strength R_p (N/mm ²)	Tensile strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J + 20°C)
450	590	35	65

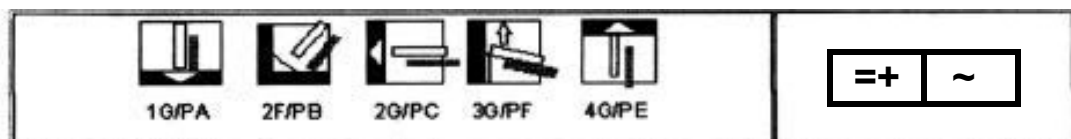
Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
50-80	70-110	110-150	150-180

Welding instruction

Keep dry and avoid condensation. Re-drying not generally required. If necessary; 300-350° C for 1 hour, 3 times max.

Welding Position



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